

Date: Friday, 9/15/2006 11:50:33 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: GHW MEDIUM BELL	
Job Number	: 28605A		Part Number	: D412729041	
Estimate Number	: 12129		Drawing Number	: DSK 092 REV B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 9/15/2006 S.O. No. : N/A		Drawing Revision	: B	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 10/15/2006 Qty: 2 Um: Each	
Previous Run	: 25683				
Written By					
Checked & Approved By					
Comment	: Est Rev:E 06.04.13 LPS3 rust inhibitor added; Hardware P/N's changed KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	DC	DOCUMENT CONTROL		
Comment: DOCUMENT CONTROL If D412-729-041 is a W/O on it's own, Photocopy bluefile and create labels per PPP D412-729-041 CHG003				JL
2.0	D27287	Decal		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2728-7 Label <u>322554</u>				(2)
<i>PPL 06-11-08</i>				
3.0	D3233041	Wheel Assembly		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3233-041 Wheel Assembly <u>B23718A-3</u> <u>→ B28609-1</u>				(2)
<i>PPL 06-11-08</i>				
4.0	D32331	Inside Washer		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3233-1 Inside Washer <u>B28610</u>				(2)
<i>PPL 06-11-08</i>				

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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5.0	D32333	Outside Washer
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) ② Pick: Qty Part Number Description Batch 2 D3233-3 Outside Washer <u>BZ861-1</u> <i>OpC 06.11.08</i>
6.0	D33091	Label
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) ② Pick: 1.0 2.0 Qty Part Number Description Batch 1 D3309-1 Label <u>BZ3767</u> <i>OpC 06.11.08</i>
7.0	D33093	Label
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) ② Pick: Qty Part Number Description Batch 2 D3309-3 Label <u>BZ3768</u> <i>OpC 06.11.08</i>
8.0	D3330041	Frame Weldment
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) ② Pick: Qty Part Number Description Batch 1 D3330-041 Frame Weldment <u>BZ8613</u> + <i>OpC 06.11.08</i> 649.85
9.0	D3331041	Handle Assembly
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) ② Pick: Qty Part Number Description Batch 1 D3331-041 Handle Assembly <u>BZ3769B</u> <i>OpC 06.11.08</i>

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Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 D3332041 Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3332-041 Long Pin Assembly B23770

(2)

PPL06-11-08

11.0 D3332043 Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3332-043 Short Pin Assembly B23771

(2)

PPL06-11-08

12.0 D33331 Base Plate Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3333-1 Base Plate B28615

(2)

PPL06-11-08

13.0 D33333 Sliding Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3333-3 Sliding Plate B28616

(2)

PPL06-11-08

14.0 D33335 Rail



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 D3333-5 Rail B28617

(2)

PPL06-11-08

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15.0	D33341	Wheel Shaft
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) (2)
	Pick:	
	Qty Part Number Description Batch	2 D33341 Wheel Shaft B28621
		<i>EPL 06-11-08</i>
16.0	D33351	Short Spring
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) (2)
	Pick:	
	Qty Part Number Description Batch	1 D33351 Short Spring B22256
		<i>EPL 06-11-08</i>
17.0	D33353	Long Spring
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) (2)
	Pick:	
	Qty Part Number Description Batch	1 D33353 Long Spring B22256
		<i>EPL 06-11-08</i>
18.0	D33361	Jack
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) (2)
	Pick:	
	Qty Part Number Description Batch	1 D33361 Jack B23772B
		<i>EPL 06-11-08</i>
19.0	AN960JD416	Washer
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) (2)
	Pick:	
	Qty Part Number Description Batch	2 AN960JD416 Washer M102339
		<i>EPL 06-11-08</i>

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Seq. #:	Machine Or Operation:	Description :
20.0	CP21	1/8" Cotter Pin 2" long
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) ②
		Pick: Qty Part Number Description Batch ✓ 2 CP-21 1/8" Cotter Pin 2" long, Span <u>m16301</u> CPL 06-11-08
21.0	HC12	1/4-20 UNC x 1" Hex Bolt
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) ②
		Pick: Qty Part Number Description Batch ✓ 1 HC-12 1/4-20 UNC x 1" long Hex Bolt, Span <u>m16529</u> CPL 06-11-08
22.0	HC29	5/16-18 UNCx1.5 Hex Bolt
		Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s) ②
		Pick: Qty Part Number Description Batch ✓ 16 HC-29 5/16"-18 UNC x 1.5" long Hex Bolt, Prof <u>m102150</u> CPL 06-11-08
23.0	HC153	3/8"-24UNFx1.25 Hex Bolt
		Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s) ②
		Pick: Qty Part Number Description Batch ✓ 8 HC-153 3/8"-24 UNF x 1.25" long Hex Bolt, Span <u>m17356</u> CPL 06-11-08
24.0	HN120	HEX SLOTTED NUT
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) ②
		Pick: Qty Part Number Description Batch ✓ 2 HN-120 1" Slotted Nut, Prof <u>m102150</u> CPL 06-11-08

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Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

HN177

5/16-18UNC Nylon LockNut



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 HN-1775/16"-18 UNC Nylon Lock Nut, Span M11d626 → 14 ←
m102150 → 18

(2)
PCL 06-11-08

✓ 26.0

HX15

1/4-20 UNCx3/4 S.H.C.S.



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 HX-15 1/4"-20 UNC x 3/4" long S.H.C.S., Span m10216626

(2)
PCL 06-11-08

✓ 27.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS21042L5 Nut (or -5) M102171

(2)
PCL 06-11-08

✓ 28.0

2333

1 1/4" Type B Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 2333 1 1/4" Type B Flat Washer (Wide), Span m16154 ←

(2)
PCL 06-11-08

✓ 29.0

18SNB

3/8" Lock Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 18-SNB3/8" Lock Washer, Span m19705

(2)
PCL 06-11-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 8611/120
 QA: N/C Closed: _____ Date: _____

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30.0	113803	1/8" PTF Grease Fitting
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Comment: Qty.: -2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: 4.0 8.00

(2)

Qty Part Number Description Batch

✓ 4.0 2 113-803 1/8" PTF Grease Fitting, Span 1.9.705

POL06-11-08

31.0	516WC	SS Flat Washer 5/16
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

✓ 16 5/16"WC Type B Flat Washer (Narrow), Prof m16988

(2)
POL06-11-08

32.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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POL06-11-15

Comment: LARGE FABRICATION RESOURCE 1

Assemble as per Dwg DSK 092. Apply LPS3 heavy duty rust inhibitor & corrosion (Procyon). Inflate wheel assembly to 90 psi. Ensure that unit goes up and down smoothly after assembly. Install decals last.

33.0	QC5	INSPECT WORK TO CURRENT STEP
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Lab-11-17 (2)

Comment: INSPECT WORK TO CURRENT STEP

34.0	PACKAGING 1	PACKAGING RESOURCE #1
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N/D

16/11/17

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

35.0	QC21	FINAL INSPECTION/W/O RELEASE
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(2)

Comment: FINAL INSPECTION/W/O RELEASE

16/11/20

Job Completion



16/11/20

W/O:		WORK ORDER CHANGES					
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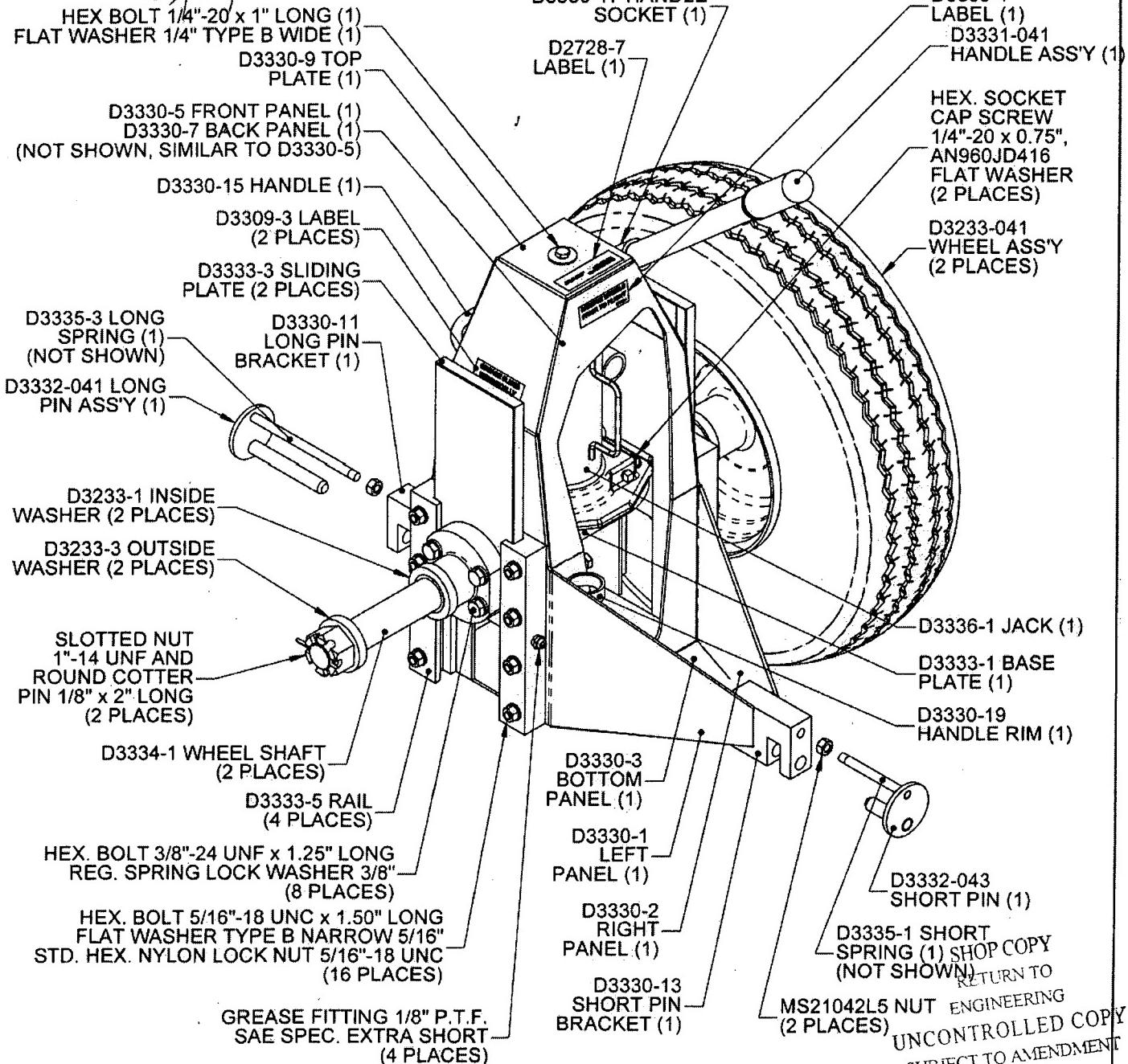
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DART

DESIGN ✓	DRAWN BY JW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PF	APPROVED JW	DRAWING NO. DSK 092	REV. B SHEET 1 OF 1
DATE	05.02.18	TITLE HYD. GROUND HANDLING	SCALE 1:5
A	04.12.06	NEW ISSUE	
B	05.02.18	REDESIGN TO FIT NEW WHEEL ASS'Y	

RELEASED
05/02/18



NOTE:

- 1) APPLY RUST INHIBITOR ON ALL PARTS AND AREAS NOT PROTECTED BY PAINT OR GREASE. RUST INHIBITOR POSSIBLE SUPPLIER: ACKLANDS-GRANGER INC., P/N LPSC30316.